

[illegible]

August 3, 2010 2:46:23 PM

Accept

[illegible]**Setup Start**

Abstract

Stop

Cust Item ID:**Start Qty:** 20.00

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Req'd Qty: 20.00[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:**

Date: 10-8-03

Tooling:

Date:

Stop

[illegible]

QC:

Date:**SPC (Y/N):**

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60981

August 3, 2010 2:46:23 PM



Page 2

Item ID:	D2873-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Assembly					
Start Date:	8/03/10	Start Qty:	20.00		Cust Item ID:	
Required Date:	8/13/10	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				20	0		
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr □2- C'sink as per Dwg D2873								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

ES 10/08/16 (20)

counted (20)

5.0608/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60981

August 3, 2010 2:46:23 PM

Page 3

Item ID: D2873-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate Assembly

Start Date: 8/03/10 Start Qty: 20.00

Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

ml 10 08 16 (20)

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

HL 10/08/16

10 9

180

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 □2-Identify as D2873-043

EP 10/08/17 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60981

August 3, 2010 2:46:23 PM

Page 4

Item ID: D2873-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate Assembly

Start Date: 8/03/10 Start Qty: 20.00

Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 20.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				20			100818
200  Packaging Packaging	Identify as per dwg & Stock Location: <i>to be easy</i> Memo	0.00 0.00				85	10-08-19		20
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/08/19 mf 10-8-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 3, 2010 2:46:28 PM

Page 1

Work Order ID: 60981

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly




Start Date: 8/03/10

Required Date: 8/13/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	33.0000	3	60			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				33					
					112243			33					
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	50.1500	0.3083	6.490526			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT01				0.45					
					113325			0.45					
				MAT04				49.7					
				→ 114352				49.7					
MS20426AD4-6  Rivet		Purchased	No			180	Each	3,133.000	6	120			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST317				3133					
					110139			3133					

8/30/08/17
M115438 (27x)

6.490 and 10/08/11
8/30/08/17
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60981
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

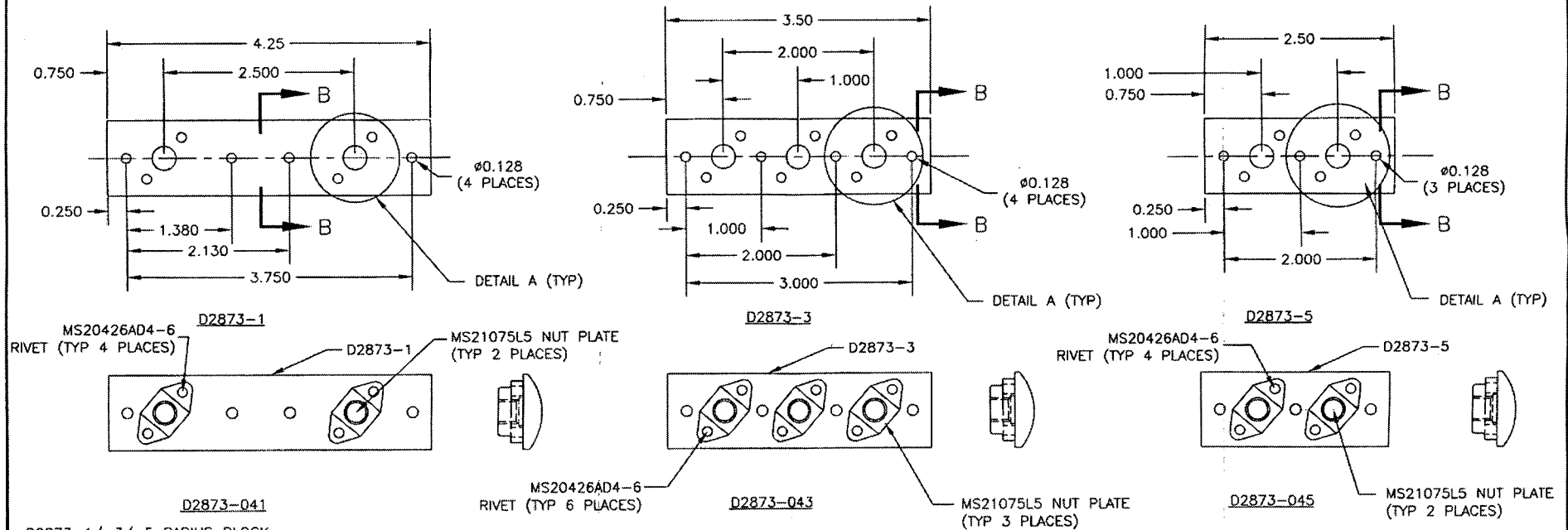
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.502	—		Vern	ML-7
2.000	+/-0.010	2.000	—		"	"
0.750	+/-0.010	.752	—		"	"
1.000	+/-0.010	1.000	—		"	"
0.250	+/-0.010	.250	—		"	"
1.000	+/-0.010	1.000	—		"	"
2.000	+/-0.010	2.000	—		"	"
3.000	+/-0.010	3.000	—		"	"
Ø0.128	+0.005/-0.001	Ø.130	—		"	"
0.359	+/-0.010	.360	—		"	"
Ø0.316	+0.006/-0.001	Ø.318	—		"	"
1.000	+/-0.010	1.003	—		"	"
0.250	+/-0.010	.253	—		"	"
0.061	+/-0.010	.062	—		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .125	—		"	"

Measured by:	<i>[Signature]</i>	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/08/14	Date:	10/08/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

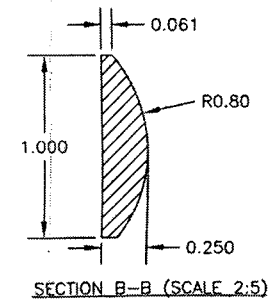
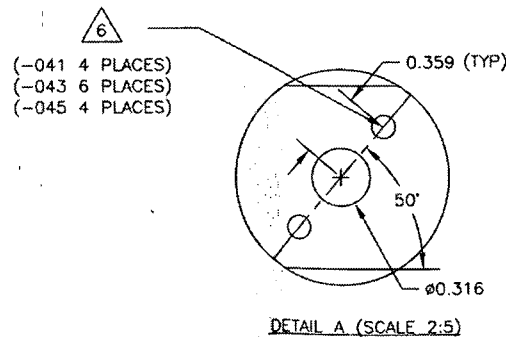
ULO 60981 PR108-03



- D2873-1/-3/-5 RADIUS BLOCK**
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE INCHES
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°
- D2873-041/-043/-045 NUT PLATE ASSEMBLY**
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKSLEY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5